

Work Order ID 108033 -2

October-07-13 9:07:00 AM

\*108033\*

Page 1

Item ID: D4095-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate Assembly

Start Date: 10/07/13 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 10/07/13 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: MJS Date: 13-10-08

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	B								
100	FLOW WATER JET	0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4095-1) Dwg Rev: 0 Prog Rev: 0 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

DAS  
27  
9-89

13 10 15

4 EL 13-10-14

4 EL 13-10-14

4

# Work Order ID 108033

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Page 2

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Item ID: D4095-041

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Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE  Memo 1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157	0.00  0.00				4			8/10/14
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Ensure joggle as per dwg D4095	0.00  0.00				4			DAS 27 9-83 B 10 16
150 *150* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch Large Fab  Memo	0.00  0.00				3			13-10-08 JBL

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Page 3

October-07-13 9:07:00 AM

Item ID: D4095-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate Assembly

Start Date: 10/07/13 Start Qty: 4.00 \*4\*

Cust Item ID:

Required Date: 10/07/13 Req'd Qty: 4.00 \*4\*

Customer:

Reference:

Run Start \*NR1\*

Stop \*NR2\*

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC10- Inspect visual per QSI004- ground welds

0.00 DAS  
27  
9-89

\*160\*

QC

Memo

0.00 13 10 18

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00 DAS  
27  
9-89

\*170\*

QC

Memo

0.00 13 10 18

Quality Control

180

0.00

\*180\*

HandFinish

Memo

0.00

Hand Finishing

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER  
DWG  
A/R ROCKGUARD BATCH: 127155

13-10-18

# Work Order ID 108033

October-07-13 9:07:00 AM

**\*108033\***

Page 4

Item ID: D4095-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate Assembly

Start Date: 10/07/13 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 10/07/13 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop **\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0.00

**\*190\***

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location STEP

0.00

**\*200\***

Packaging

Memo

0.00

Packaging

DAS  
33  
9-89

13-10-18

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

*[Handwritten signature]* / 13-10-18

*[Handwritten signature]* 13-10-11

# Picklist Print

October-07-13 9:07:00 AM

Page 1

Work Order ID: 108033

Parent Item: D4095-041

Parent Item Name: Wearplate Assembly

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	513.3940	2.275	9.5789472			
304/316 Sheet .063													

EL 13-10-14

Location

Loc Qty

Loc Code

MAT020

513.3939998

123136

140.2

M126159

31.5

M126915

341.694

7.6'

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 108033
<b>Description: Wearplate</b>		<b>Part Number:</b> D4095-1
<b>Inspection Dwg: D4095</b>	<b>Rev: B</b>	<b>Page 1 of 1</b>

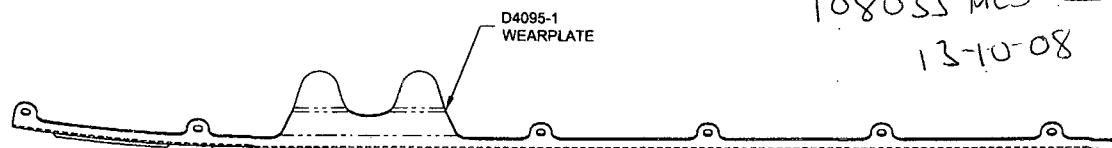
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.190	✓		✓ Jkmoi	
0.300	+/-0.010	0.303	✓		"	
0.300	+/-0.010	0.302	✓		"	
2.432	+/-0.010	2.44	✓		"	
3.227	+/-0.010	3.221	✓		"	
4.06	+/-0.030	4.05	✓		"	
4.98	+/-0.030	4.984	✓		"	
8.43	+/-0.030	8.422	✓		"	
9.22	+/-0.030	9.22	✓		T Jkmoi	
3.500	+/-0.010	3.5	✓		"	
24.750	+/-0.010	24.75	✓		"	
11.50	+/-0.030	11.5	✓		"	
11.472	+/-0.010	11.472	✓		"	
6.000	+/-0.010	6	✓		"	
12.104	+/-0.010	12.104	✓		"	
18.000	+/-0.010	18	✓		"	
30.000	+/-0.010	30	✓		"	
9.00	+/-0.030	9	✓		"	
36.000	+/-0.010	36	✓		"	
38.87	+/-0.030	38.875	✓		"	
2.50	+/-0.030	2.5	✓		"	
0.063	+/-0.010	0.06	✓		✓ Jkmoi	

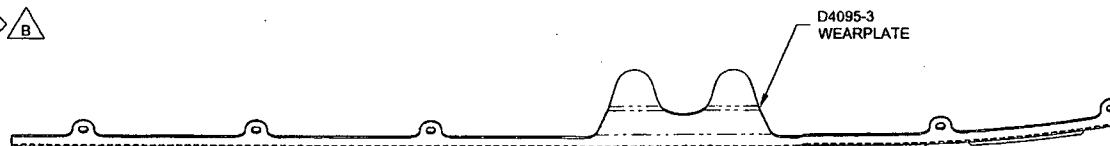
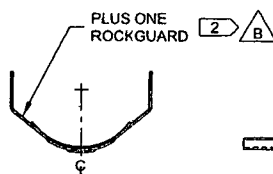
<b>Measured by:</b> EL	<b>Audited by:</b> DAS 27	<b>Preliminary Approval:</b>
<b>Date:</b> 13-10-14	<b>Date:</b> 13-10-15	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-041	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

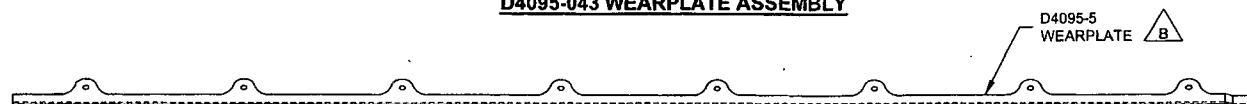
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



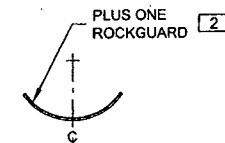
**D4095-041 WEARPLATE ASSEMBLY**



**D4095-043 WEARPLATE ASSEMBLY**



**D4095-045 WEARPLATE ASSEMBLY**



**D4095-041/-043/-045/-047/-049/-051 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		

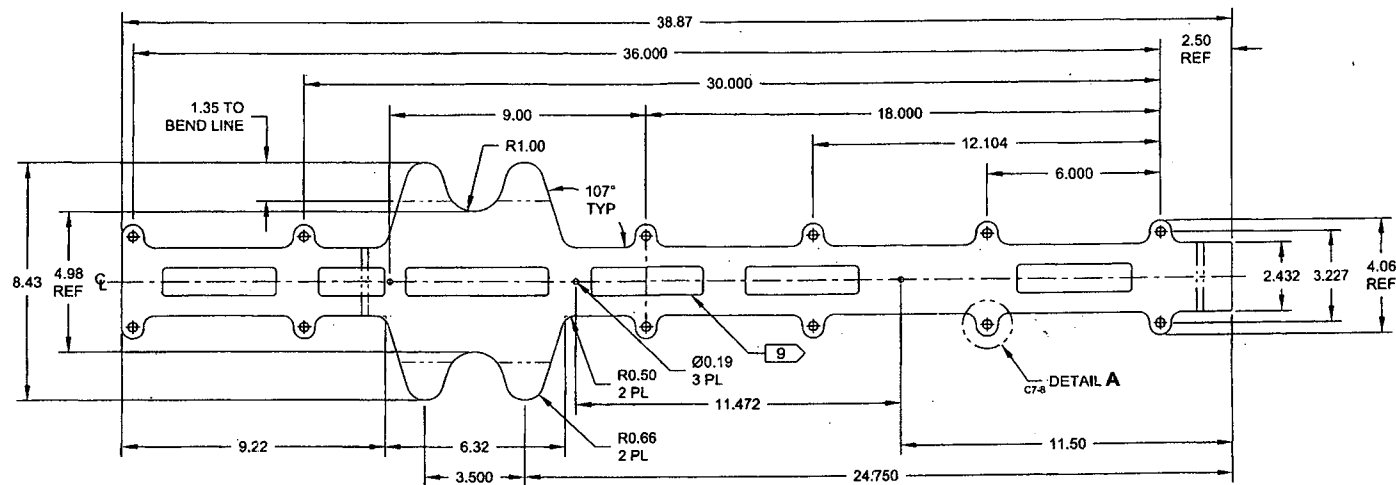
**DART AEROSPACE USA, INC**  
KENT, WA

DRAWING NO. D4095  
TITLE WEARPLATE

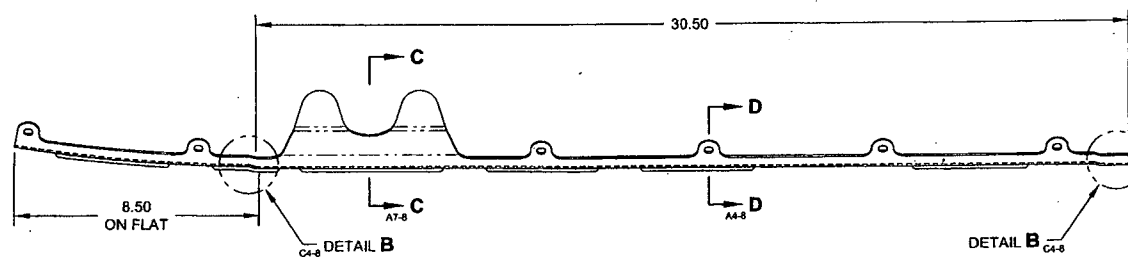
REV. B  
SHEET 1 OF 8  
SCALE NTS

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108033



**D4095-1F FLAT PATTERN**



**D4095-1 BENDING DETAIL**  
(MAKE FROM D4095-1F)

**D4095-1/1F/3/3F/5/5F/7/7F/9/9F/11/11F NOTES:**

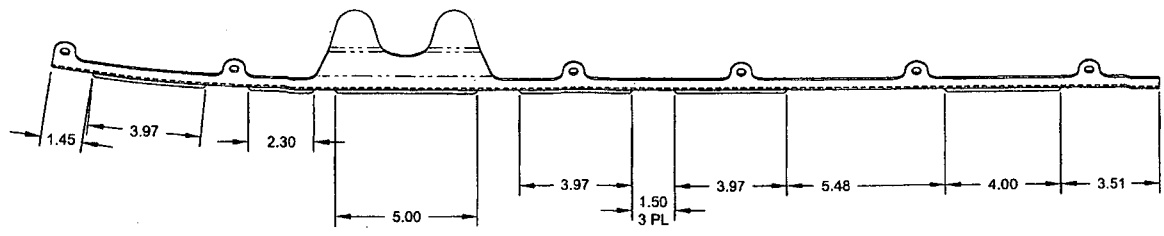
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240  
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

RELEASED  
2011-10-31

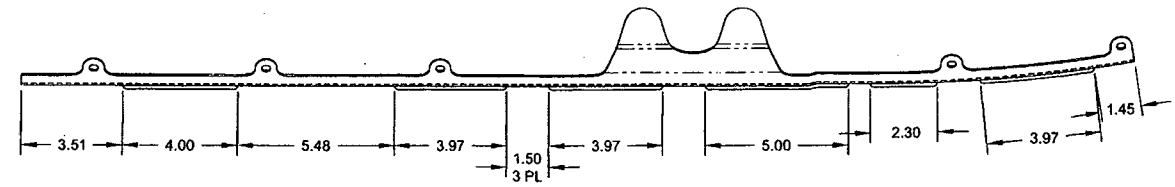
DESIGN	1	<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 3 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
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108033



**D4095-1 WELDING DETAIL** B

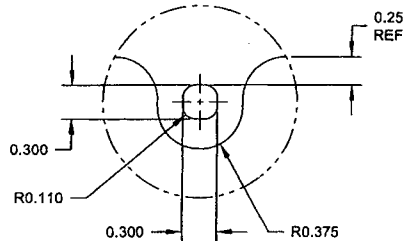


**D4095-3 WELDING DETAIL** B

RELEASED  
2011-10-31  
MP

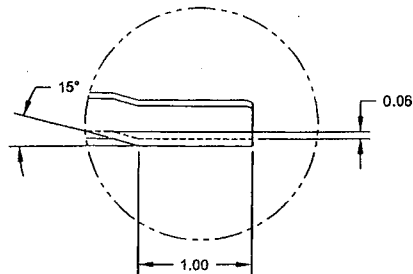
DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 5 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
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108 033



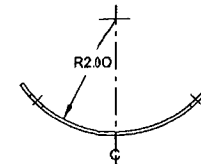
**DETAIL A: TAB DETAIL**

SCALE 4X  
C3-3  
C3-4  
D3-6  
D2-7



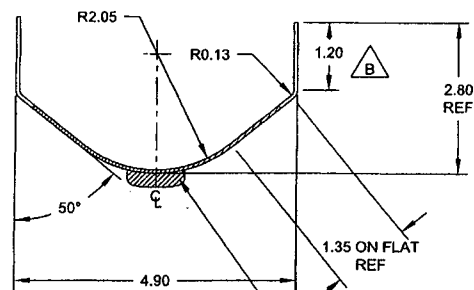
**DETAIL B: JOGGLE DETAIL**

SCALE 4X  
B2-3  
B6-3  
B3-4  
B2-6



**SECTION E-E**

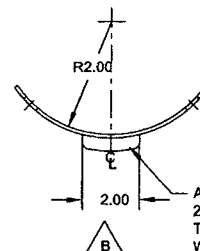
SCALE 2X  
B5-6  
B2-7



**SECTION C-C**

SCALE 2X  
B5-3  
B4-4

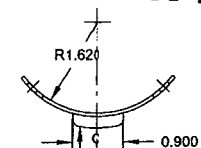
APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK



**SECTION D-D**

SCALE 2X  
B4-3  
B5-4

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK



**SECTION F-F**

SCALE 2X  
B5-7  
B7-7

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

RELEASED  
2011-10-31  
NP

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
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